

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008673**Date Inspected:** 20-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3BW. The weld designations reviewed are as follows:

3BW

1. SEG015B-006
2. SEG015B-004
3. SEG013B-046
4. LD012-001-007

1AW

1. SEG003B-017

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1AAE +1BE

FCAW welding of weld joint 007 located on OBE1.

Welder is identified as Mr. Yang Changming (058242). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and repair procedure B-WRR6870.

FCAW welding of weld joint 007 located on OBE1.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and repair procedure B-WRR6870.

1AE

SMAW welding of weld joint 002 located on CA107B.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-TC-U4b-FCM-1.

SMAW welding of weld joint 106 located on SEG2C.

Welder is identified as Mr. Yun Chengxian (045138). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-TC-U4b-FCM-1.

SMAW welding of temporary brace located on BK3 cantilever member.

Welder is identified as Mr. Zhang Xiaochong (220068). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of weld joints 005 and 006 located on SEG004B.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

SMAW welding of weld joint 001 located on CA108B.

Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
